

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018346**Date Inspected:** 26-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower / OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #10

This QA Inspector observed the following work in progress

Tower

Shielded Metal Arc Welding (SMAW):

Repair welding of Weld joint # 4 located on South shaft, Lift 6 Skin plate to stiffener, SSD1-FASA6-1. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) -Repair.

ORTHOTROPIC BOX GIRDER (OBG)

Flux Cored Arc Welding (FCAW):

Weld joint # 016 located on Bike path BK004A2 -029. Welder is identified as 040367. ZPMC Quality Control

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(QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B-U4B -F.

Weld joint # 018 located on Bike path BK004A2 -029. Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B-U4B -F.

Weld joint # 044 located on Traveler rail Bracket TR 6 in P.P 102. Welder is identified as 040458. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Bay #11

Tower

Flux Cored Arc Welding (FCAW)

Weld joint # 5 located on Lift 6 Skin plate to stiffener WSD1-FDSA6 -4. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 6 located on Lift 6 Skin plate to stiffener WSD1-FDSA6 -4. Welder is identified as 040736. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Submerged Arc welding (SAW)

Weld joint # 1 located on Lift 6 Skin plate SSD1-DPSA6 -5. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 –B – U3C –S -2.

Heat Straightening:

Heat Straightening being performed on West Tower, Lift 6 Skin Plate WSD1 –FDSA6 -4 -6, 8 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Xu Le Feng present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (T) – 11624.

ORTHOTROPIC BOX GIRDER (OBG)

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Flux Cored Arc Welding (FCAW):

Weld joint # 023, 024 located on Bike path BK004A8-023. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T - 2132.

Weld joint # 023, 024 located on Bike path BK004A6-023. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T - 2132.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007504

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a TL 6028 MT report for this date. The member is identified as Tower Fit lug components. The weld designations reviewed are as follows:

NSTL4 -3C/L – Jt. no. -098

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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